

**Work Order ID 108313**

Wednesday, October 16, 2013 8:56:12 AM

**\*108313\***

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Item ID: D3121-241

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Bearing Assembly

Stop

**\*NS2\***

Start Date: 10/16/2013 Start Qty: 50.00

**\*50\***

Cust Item ID:

Required Date: 10/16/2013 Req'd Qty: 50.00

**\*50\***

Customer:

Reference:

Approvals: Process Plan: WIFDate: 13-10-16 Tooling:

Date:

Run Start

**\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_ SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3121	Rev E								
130		0.00							
<b>*130*</b>	Small Fab								
Small Fab									
Small Fab									
	Memo	0.00							
	1-Press D3121-23 Bearing into D3121-25 Cap as per Dwg D3121								

140	QC5- Inspect part completeness to step on W/O	0.00	DAS 27 9.89	50	8/3/16
<b>*140*</b>	QC				
Quality Control	Memo	0.00	13-10-16	50	8/3/16

150	Identify as per dwg & Stock Location: <u>ST235</u>	0.00	DAS 28 9.89	50X	13-10-16
<b>*150*</b>	Packaging				
Packaging	Memo	0.00			

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Start Date: 10/16/2013 Start Qty: 50.00

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Cust Item ID:

Required Date: 10/16/2013 Req'd Qty: 50.00

\*50\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

\*160\*

QC

Memo

0.00

Quality Control

10/13-10-17

10/13-10-17

# Picklist Print

Wednesday, October 16, 2013 8:56:11 AM

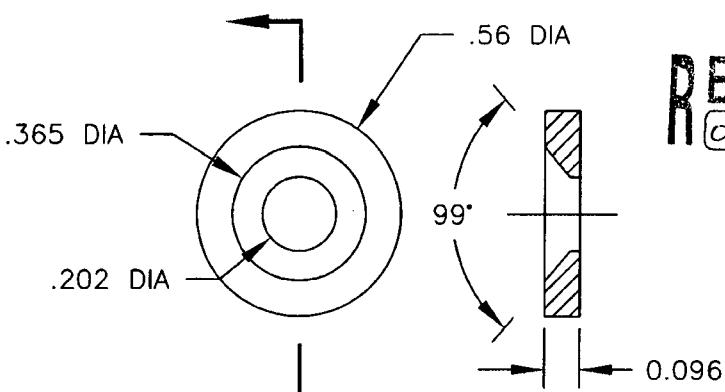
Page 1

**Work Order ID:** 108313 1  
**Parent Item:** D3121-241 **Start Date:** 10/16/2013 **Required Date:** 10/16/2013  
**Parent Item Name:** Bearing Assembly **Start Qty:** 50.00 **Required Qty:** 50.00  
**Comments:** IPP Rev:A04.02.18New issueKJ/DS  
 IPP Rev:B ECN 1060 07-11-12 DD verified by:EC

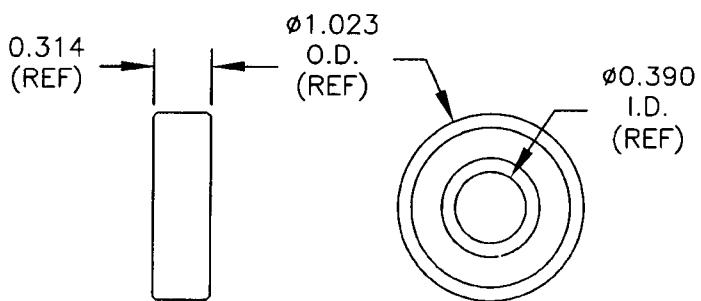
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3121-25 Delrin Cap		Manufactured	No				Each	182.0000		50	13/10/16		DAS 36 9.89
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST235			182						
				102340			27						
				102767			60						
				105445			95						
D3121-23 Bearing		Manufactured	No				130	Each	107.0000	1	50	13/10/16	DAS 36 9.89
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST235			107						
				105954	—		33				33		
				108218			60				17		
				66734			10						
				75084			2						
				99000			2						

**DART**

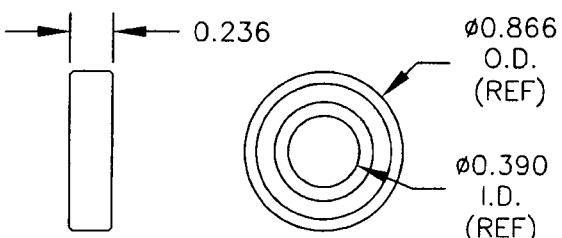
DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	DRAWING NO.	HAWKESBURY, ONTARIO, CANADA
		D3121	REV. E
DATE	TITLE	SCALE	SHEET 10 OF 10
07.11.07	BRACKET ASSEMBLY	1:1	

**D3121-17 WASHER (SCALE 2:1)**

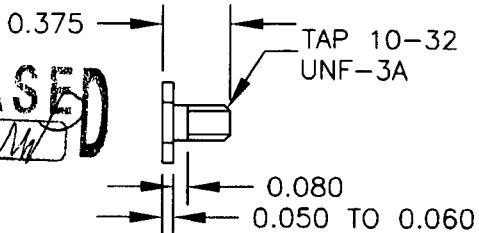
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM  
FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

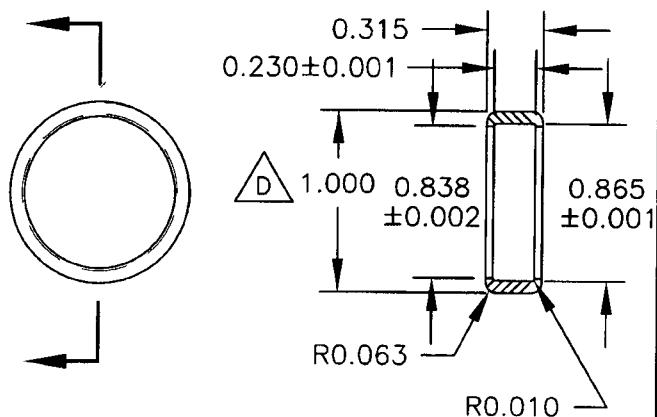
- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z  
OR KML P/N 6900-2Z
- 2) ALL DIMENSIONS ARE IN INCHES



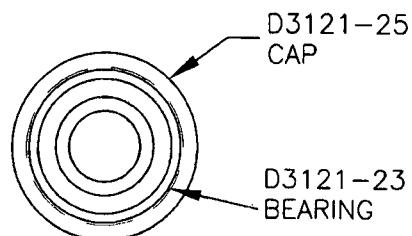
RELEASER  
07.11.07 M

**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**